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50X1-HUM

After heating, the cutter is left on the stove and welded. An 8- to 10-mm seam is welded from one end of a break, the cutter is turned over, and a seam of the same length is applied at the other end. These steps are repeated until the weld is completed on both sides. After this, the cutter is covered with the asbestos sheet, the current is cut off from the stove, and the cutter and stove are allowed to cool. The seam is ground off flush and the cutter is returned to service.

In welding cracks, abrasives are used to separate the sides to a depth of one millimeter on both sides of the cutter. The ends of the crack are then tack-welded without preheating. Thereafter, the process is the same as that for a broken cutter.

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